

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	D-PAD BASE		
Job Number	40037			Part Number	PB6743001193		
Estimate Number	13388			Drawing Number	B67-43001 P.25		
P.O. Number	:			Project Number	N/A		
This Issue	24/06/2008	S.O. No.	:	Drawing Revision	B1		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	01/07/2008	Qty:	40
Previous Run	:			Um:	Each		
Written By	:						
Checked & Approved By	MF 08-06-24						
Comment	est rev A new issue 08.06.19 EC verified: DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
 Comment: Qty.: 0.0116 sf(s)/Unit Total: 0.4620 sf(s) 6061-T6 .125Sheet 106634 BS 8-8-7 batch: 106634 BS 8-6-24		
2.0	WATER JET	FLOW WATER JET
 Comment: FLOW WATER JET 1-Cut as per Dwg. BS 8-8-7 59 Dwg Rev: B1 BS 8-6-24 Prog Rev: B1 BS 8-8-7 59 BS 8-6-24 54 BS 8-8-7 54 2-Deburr if necessary BS 8-6-24 54 BS 8-8-7 54 BS 8-8-7 54 BS 8-8-7 54 BS 8-8-7 54 BS 8-8-7 54 BS 8-8-7 54		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
 Comment: SECOND CHECK		
5.0	MS21075L3	Nutplate
 Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s) Nutplate M108757 88X M108560 30X BS 8-8-08 batch: 108560 108757 1087277 BS 8-8-08		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O: 40037	Est. # 13388	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Permit change CCR264553 Revt to the correct CCR264553 B# AS per Dwg.				0807-10	0807-10

Part No: P86743001193 PAR #: Shrt Fault Category: Production Engineering NCR: Yes No DQA: PD Date: 08/08/08
Co-ordinator QA: N/C Closed: PD Date: 08/08/08

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07-10	6.0	The incorrect rivets were listed on the w/o in accordance to the dwg.	<u>J</u>	- Retrain Employee to relate part → drawing → work instructions. Always check	08/07/10	<u>Getek7</u>	<u>J</u>	<u>J</u>
	7.0	- Production installed the incorrect rivets on top of e'sunk holes.	<u>0807-10</u>	- remove all incorrect rivets. Inspect hole condition Q.C. See Bottom box.	08/07/10	<u>Getek7</u>	<u>0807-10</u>	<u>0807-10</u>
		R. c: lack of attention, and verification by both parties. Production Engineering co-ordinating.	<u>0807-10</u>	- rework AS per dwg	<u>EB</u> 08/08/08	<u>Getek7</u>	<u>0807-10</u>	<u>0807-10</u>
			<u>0807-10</u>	- All holes are oversized and not accurately. Scrap and destroy <u>Qty 154</u> and Replace <u>B# 106634</u>	<u>B</u> 08/07	<u>Getek7</u>	<u>0807-10</u>	<u>0807-10</u>

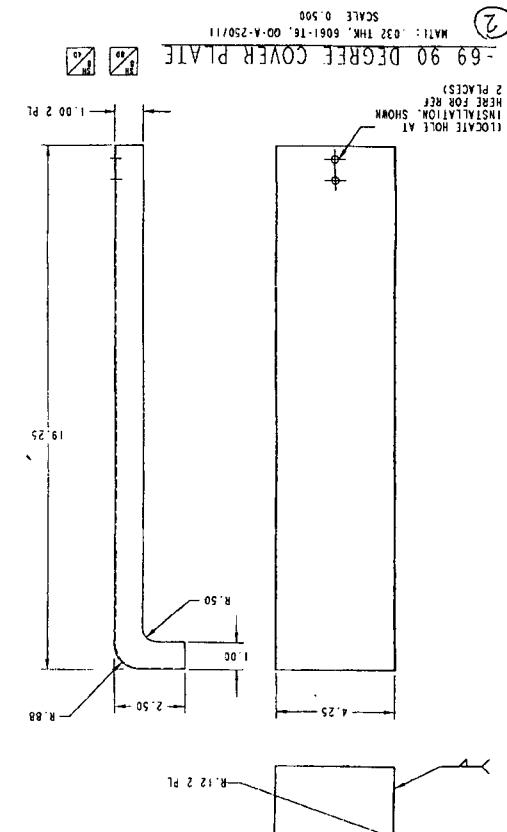
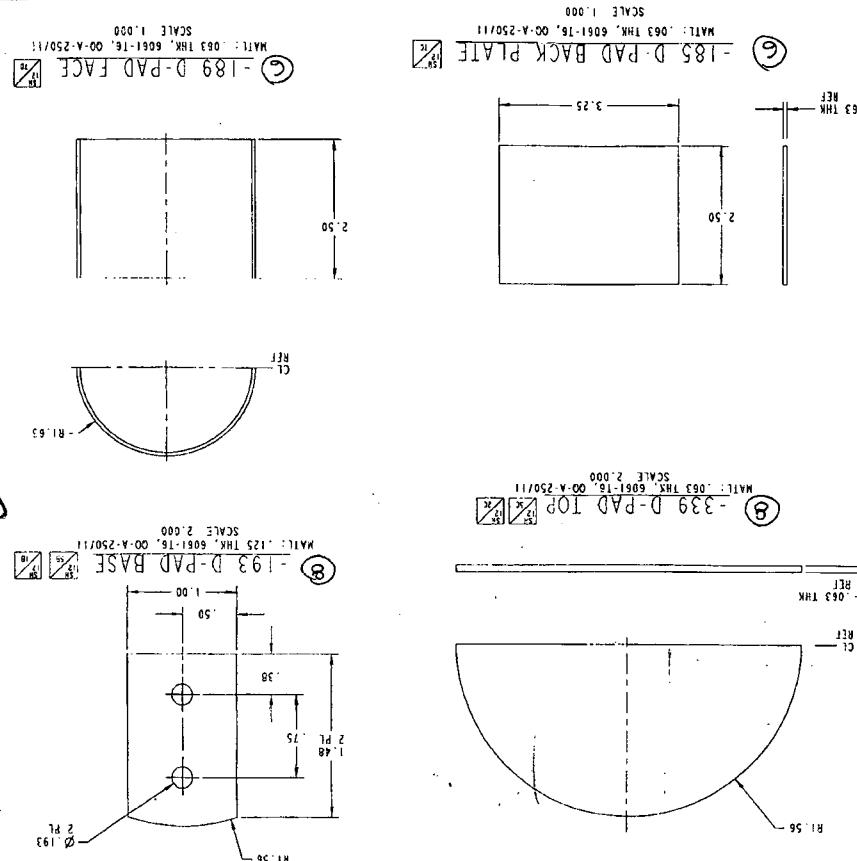
NOTE: Date & initial all entries

Lesson #

RELEASED
2014-01-23

REFERENCE ONLY

REERENCE ONLY



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DART AEROSPACE LTD	Work Order:	
Description: D-PAD BASE	Part Number:	367-43001-193
Inspection Dwg: 18 Rev: R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BS
Date:	8-6-23

Audited by: 8
Date: 06/06/03

Prototype Approval:	<i>1</i>
Date:	<i>2</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	40037
Description: D-PAD BASE	Part Number:	DB674 3001-193
Inspection Dwg:	Rev: B1	Page 1 of 1

PB 674 3001 - 193

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	18	Audited by:		Prototype Approval:	1
Date:	8-8-7	Date:	08/08/07	Date:	7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	